

Date: Thursday, 3/23/2006 3:40:39 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L/407 STEP ASSY, LH		
Job Number	: 26346A					
Estimate Number	: 11702					
P.O. Number	: N/A			Part Number	: D2724041	
This Issue	: 3/23/2006	S.O. No.	: N/A	Drawing Number	: D2724 REV C	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A	Type	: LARGE FAB ASSY	Drawing Revision	: C	
Previous Run	: 25448A			Material	: N/A	
Written By	: See 1 Document Below			Due Date	: 4/15/2006	
Checked & Approved By	: JLM			Qty:	3 Um: Each	
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>B24663</u>

Check Material for any Dents or Defects

LE 06-04-20

3

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724  
 Debur and bevel ends for welding

LE 06-04-20

3

3.0	D2734	206 Step Endplate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>B24402</u>

LE 06-04-21

3

4.0	D34581	PLATE
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	<u>B25418 = 7</u>

LE 06-04-21

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:40:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206L/407 STEP ASSY, LH
Job Number: 26346A		Part Number: D2724041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	D34583	PLATE 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)		
Pick: Qty Part Number Description Batch	2 D3458-3 Plate	326417 = 6 
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig DT (One End Only) A/R AL ROD Batch: <u>m19173 m18838</u>		 <i>FE. 06-04-21 3</i>
Grind end cap welds flush		
7.0	QC5/9	WELD INSPECTION 
Comment: WELD INSPECTION		 <i>FE. 06-04-27 3</i>
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		 <i>FE. 06-04-29 3</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 <i>DA 06/05/01 (3)</i>
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		 <i>FE 06-05-03 3</i>
Inspect for foreign object per QSI 024		
Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig DT A/R AL ROD Batch: <u>m18838</u>		 <i>FE. 06-05-03 3</i> <i>FE. 06-05-03 3</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:40:40 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206L/407 STEP ASSY, LH
Job Number: 26346A		Part Number: D2724041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
11.0	QC5/9	WELD INSPECTION
		
Comment: WELD INSPECTION		 <i>R 06/05/03 (3) M 06/05/03 (3)</i>
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1		
Touch up Alodine		<i>DC 06/05/03 (3)</i>
13.0	POWDER COATING	POWDER COATING
		
Comment: POWDER COATING		
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<i>DC 06/05/03 (3)</i>
14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>FC 06/05/04 (3)</i>
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4		<i>FC 06/05/04 (3)</i>
16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>FC 06/05/04 (3)</i>
17.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: _____		<i>N/A</i>
18.0	DC	DOCUMENT CONTROL
		
Comment: DOCUMENT CONTROL		
Inspection Level 21		
Job Completion		
		<i>DC 06/05/04 (3) 06/05/05 U 06/05/04</i>

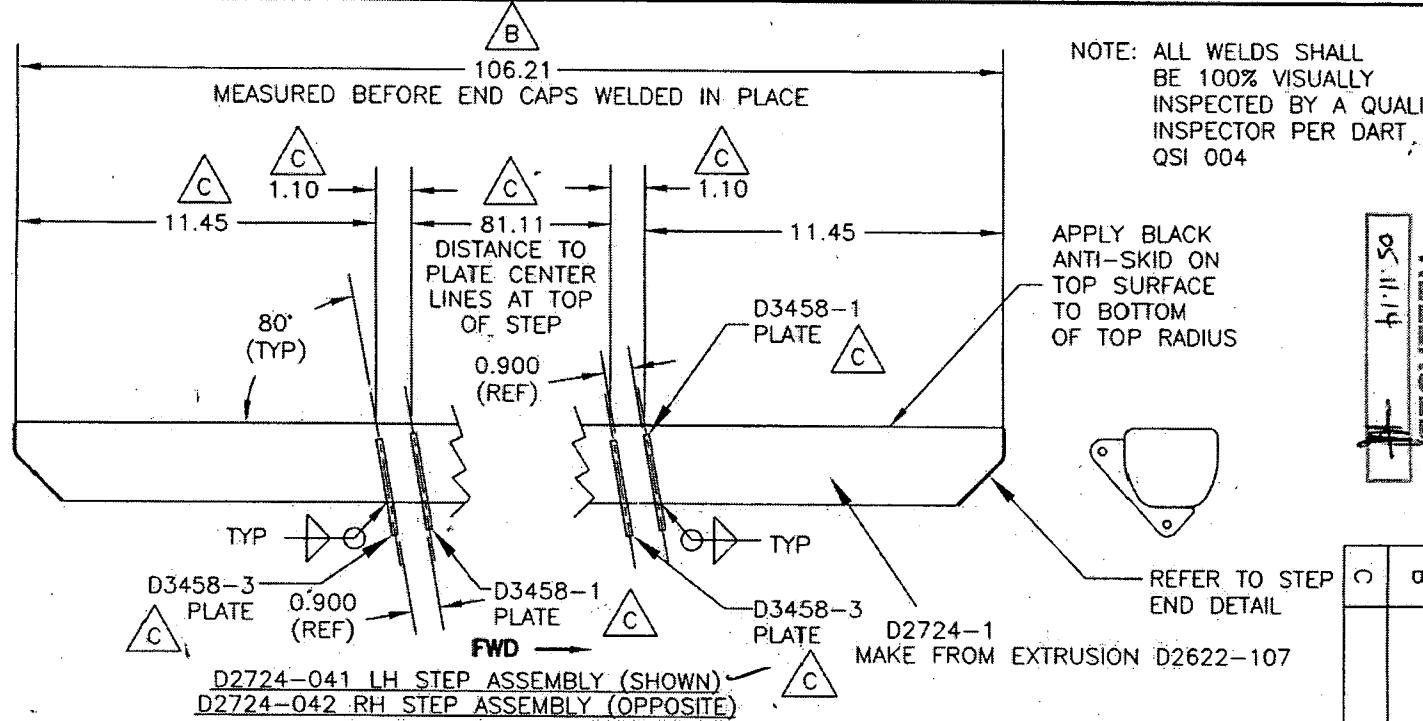
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

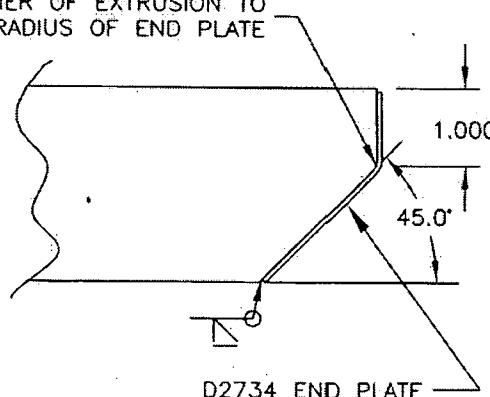
**DART****D2724-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
X		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 2622-107-A



TYPICAL STEP END DETAIL  
NOT TO SCALE

**B**

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2724
DATE		REV. C
A	97.12.04.	NEW ISSUE
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
C	05.09.19	RE-DESIGN, ADD D3458-1/-3

SHEET 1 OF 1  
SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries